

Date: Monday, 02/02/2009 7:28:24 AM
 User: Jean-Luc Menard

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	NUT PLATE ASSEMBLY
Job Number :	45375		
Estimate Number :	13758		
P.O. Number :		Part Number :	D3877043
This Issue :	02/02/2009	Drawing Number :	D3877 PREL
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11	Drawing Revision :	PREL
Previous Run :		Material :	
Written By :	<u>09-02-02</u>	Due Date :	09/02/2009
Checked & Approved By :		Qty:	6 Um: Each
Comment :	Est Rev:A/ New Issue 09-01-30 JLM Verified By:EC		

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X00750	6061T6 BAR .375 x .750
-----	--------------------	------------------------



Comment: Qty.: 0.3893 f(s)/Unit Total : 2.3360 f(s)
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6B0.375x00.750) Batch: m18037

X

mmf 09/02/02

⑥

2.0	BAND SAW	BAND SAW
-----	----------	----------

**Comment:** BAND SAW

Cut blanks: 0.750" x 0.375" x 2.750" long

mmf 09/02/02

⑥

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA798 and Dwg D3877
 Dwg Rev Red Folio Rev A

mmf 09/02/02

⑥

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/02/02

⑥

5.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

09-02-03

⑥

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 45375

Part Number: D3877043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2- C'sink as per Dwg D3877

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

10.0

MS21069L5

Nutplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nutplate

BATCH: 1110765

11.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Rivet

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2872

2-Identify as D2872-041

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

Date: Monday, 02/02/2009 7:28:24 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 45375

Part Number: D3877043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/03/24

(6)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09-02-02

AUTH L

RELEASED

09-03-24

DATE

09-03-24

GP

09.03.25

ART AEROSPACE LTD		Work Order:	45375
Description: RADIUS BLOCK		Part Number:	D3877-043
Inspection Dwg:	Rev: P10	Page 1 of 1	

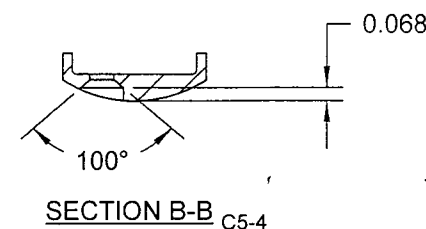
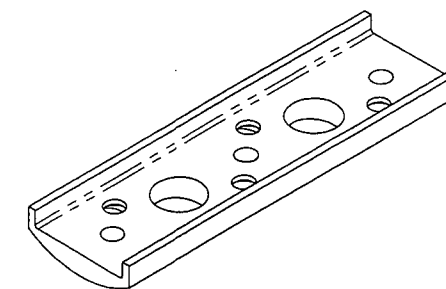
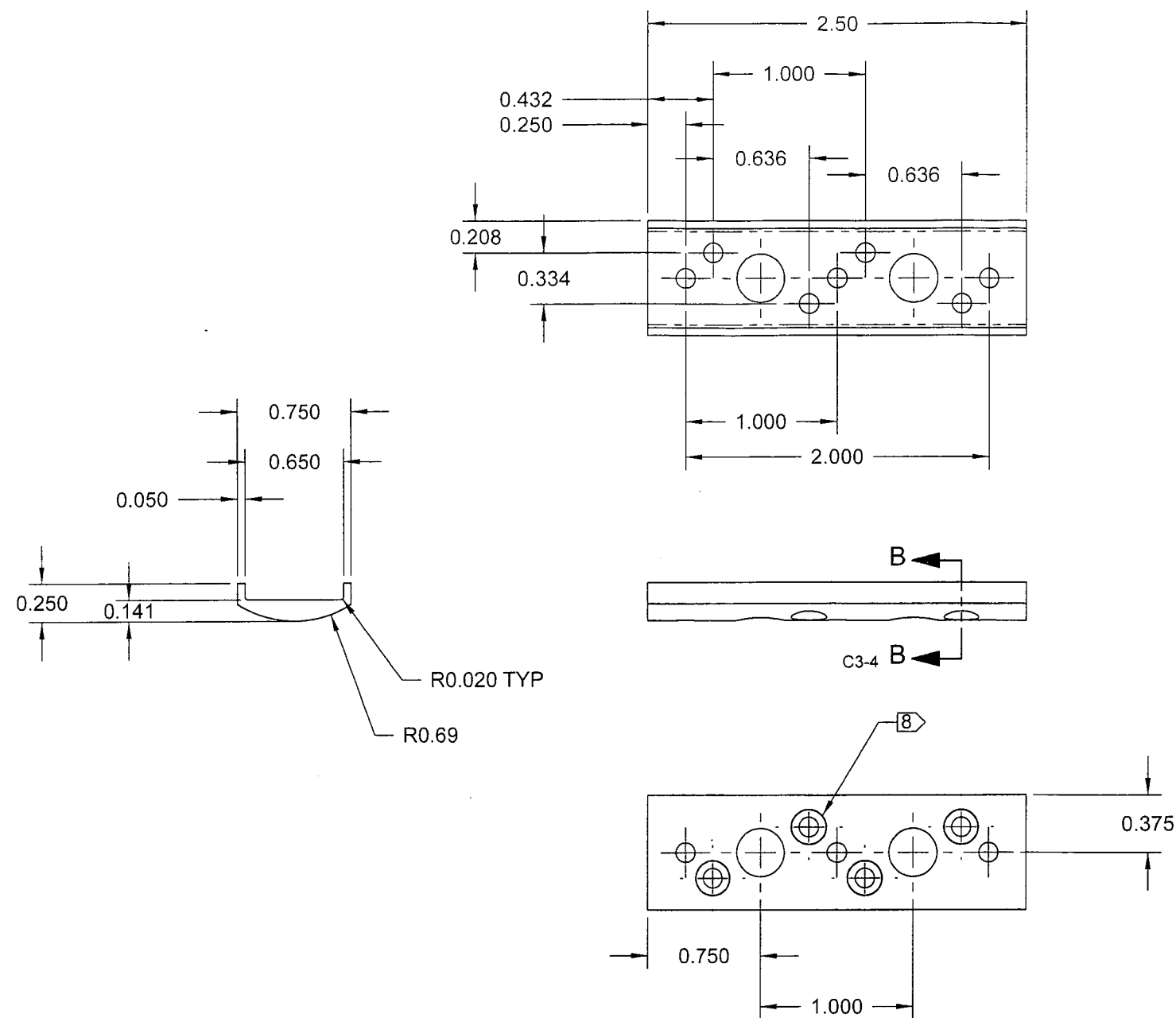
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.750	± .010	.750	✓			
.650	± .010	.650	✓			
.050	± .010	.051	✓			
.250	± .010	.249	✓			
.141	± .010	.140	✓			
2.50	± .030	2.50	✓			
2.000	± .010	2.000	✓			
1.000	± 1.000	.999	✓			
1.000	± 1.000	.999	✓			
.636	± .010	.635	✓			
.636	± .010	.636	✓			
.432	± .010	.432	✓			
.250	± .010	.249	✓			
.334	± .010	.334	✓			
.208	± .010	.208	✓			
.375	± .010	.375	✓			
R.020	± .010	R.015	✓			
R.69	± .030	R.69	✓			

Inspected by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 09/02/02	Date: 09-02-03	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	P10 D3877-043	KJ/JLM



D3877-3 RADIUS BLOCK

10.799

**PRELIMINARY
ISSUE**

09.01.21

45375

NOTES:

- 1) MATERIAL: 5052-H32/H34 BAR (REF DART SPEC. H5052H32B0.750X00.250)
OR 6061-T6 BAR (REF DART SPEC. M6061T6B0.750X00.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) C'BORE INDICATED HOLES ON CURVED SIDE $\phi 0.230 \times 0.068$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$ (SEE SECTION B-B), 4 PL

DESIGN	<i>GP</i>	DART AEROSPACE LTD	
DRAWN	<i>GP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PA</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>Ind</i>	D3877	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RADIUS BLOCK	NTS
DATE	09.01.19	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

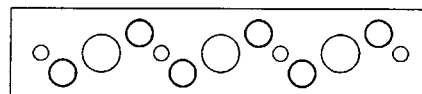
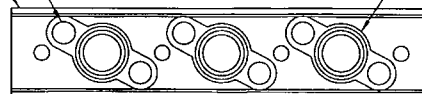
PARTS LIST

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3877-041	RADIUS BLOCK
2	1	D3877-1	RADIUS BLOCK
3	3	MS21069-L5	NUTPLATE
4	6	MS20426AD4-5	RIVET

MS20426AD4-5 RIVET
6 PL

D3877-1

MS21069-L5 NUTPLATE
3 PL

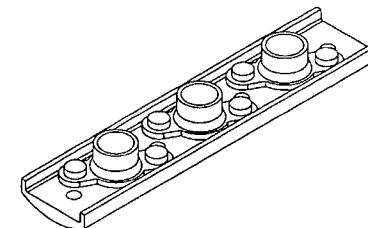


D3877-041 RADIUS BLOCK

45375

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3877-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs



RELEASED
09/03/24 JHP

A	NEW ISSUE	CP	09.01.19
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	09.01.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3877** REV. A SHEET 1 OF 4

TITLE **RADIUS BLOCK** SCALE NTS

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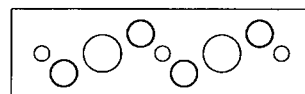
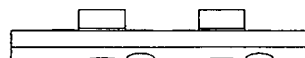
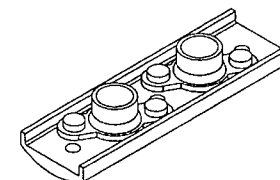
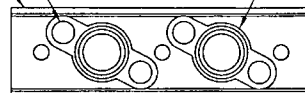
PARTS LIST

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3877-043	RADIUS BLOCK
2	1	D3877-3	RADIUS BLOCK
3	2	MS21069-L5	NUTPLATE
4	4	MS20426AD4-5	RIVET

MS20426AD4-5 RIVET
4 PL

D3877-3

MS21069-L5 NUTPLATE
2 PL



D3877-043 RADIUS BLOCK

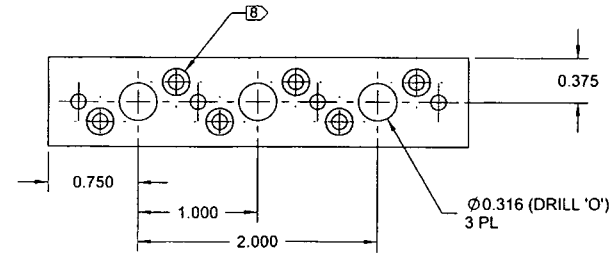
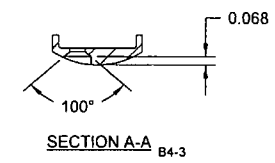
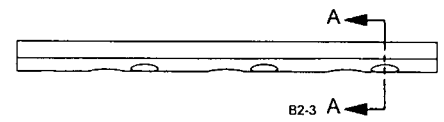
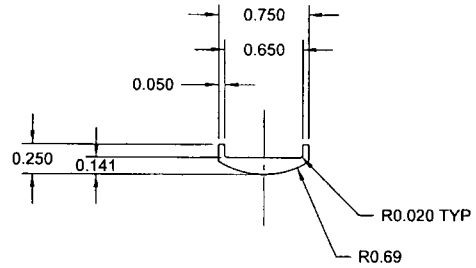
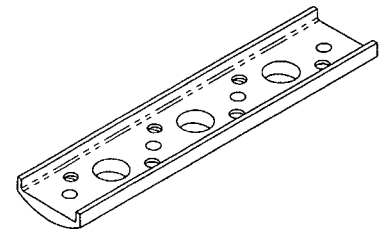
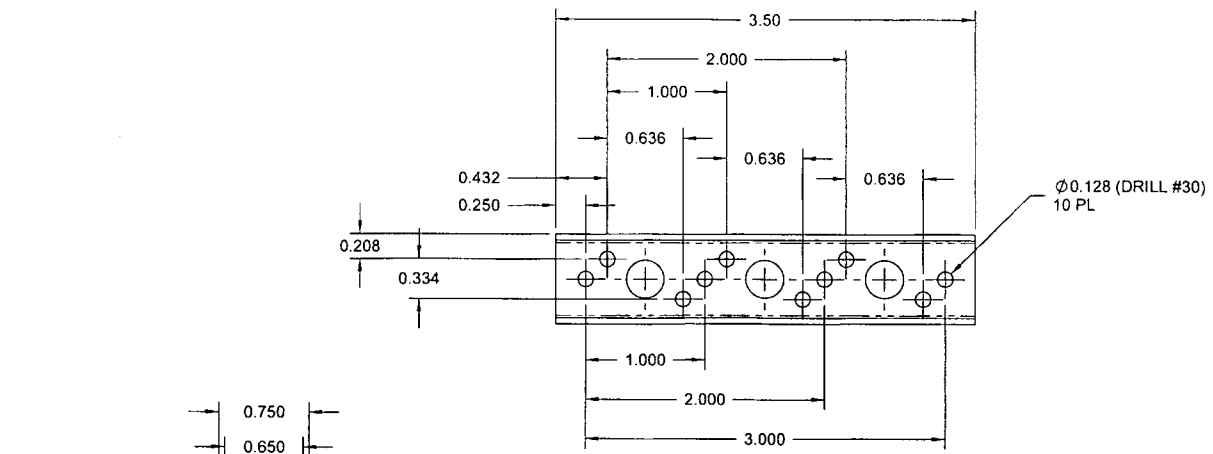
45375

RELEASED
01/03/24 M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3877-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3877	SHEET 2 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	RADIUS BLOCK	NTS
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45375

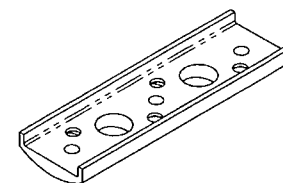
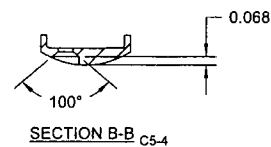
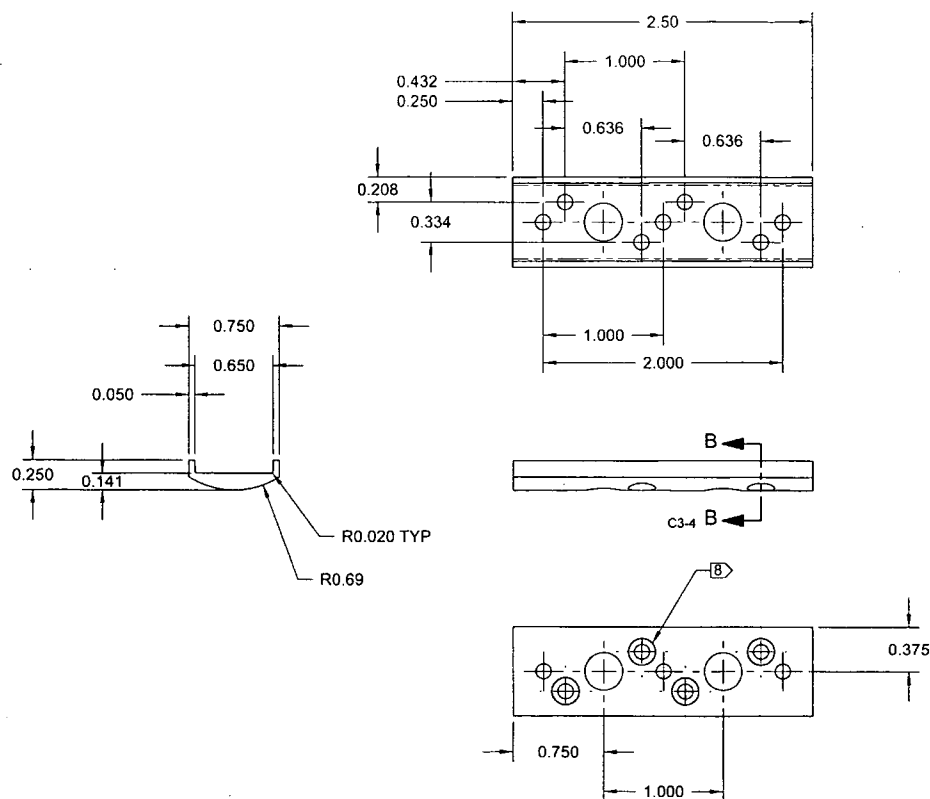
D3877-1 RADIUS BLOCK

RELEASED

NOTES:

- 1) MATERIAL: 5052-H32/H34 BAR PER QQ-A-225/7 (REF DART SPEC. M5052H32B0.750X00.250)
OR 6061-T6 BAR PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC. M6061T6B0.750X00.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs
- 8) C'BORE INDICATED HOLES ON CURVED SIDE Ø0.230x0.068 DEEP + C'SINK CURVED SIDE Ø0.225x100* (SEE SECTION A-A), 6 PL

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3877	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RADIUS BLOCK	NTS
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



D3877-3 RADIUS BLOCK

45375

NOTES:

- 1) MATERIAL: 5052-H32/H34 BAR PER QQ-A-225/7 (REF DART SPEC. M5052H32B0.750X00.250) OR 6061-T6 BAR PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC. M6061T6B0.750X00.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) C'BORE INDICATED HOLES ON CURVED SIDE $\phi 0.230 \times 0.068$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$ (SEE SECTION B-B), 4 PL

RELEASED
9/15/24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3877	SHEET 4 OF 4
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DE APPR.		RADIUS BLOCK	NTS
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